

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: **2016-47** Date Opened: **22 March 2016** Title: **Fabrication**Aircraft OEM: **Eurocopter** Aircraft Model: **AS350** Product Type: **Cargo Basket** Product Model: **Attach Hoops** Quantity: **10 Med /20 Long****Work Order Contents**

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JC
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JC
Parts Distribution Sheet	JC
Sub Component Tags	N/A
Completed Certification (Original)	N/A
Time Sheet (R&D)	N/A
Notes	N/A

**Build Sheet Contents**

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
76423	1	Attach Hoop	JC

**Traveller**

Initial or N/A

**Component Completion**

	As Instructed
Quantity Complete on This Work Order	N/A
Quantity Incomplete on This Work Order	N/A
Further Processing Required Before Release	N/A
Release to Stock as Components	10/20

**Certification**

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Tracking (White) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

**Additional Documentation**

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

**Billing**

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by:

Print: D. Bartfai

Sign: 

SCA: AD07

Date: 16-Dec-16

ICC / Dual Inspection performed by:

Print: N/A

Sign: 

SCA:

Date:

Work Order closed by:

Print: J. Clarke

Sign:

SCA: AD02

Date: 13-Mar-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

## CARGO BASKET HOOP FABRICATION - 76423

### General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

### Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order:

2016-47-A x 5 Medium

Date Open:

22 Mar 16

Complete  
(initial or SCA #)

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
<u>07</u>	<u>07</u>	<u>07</u>	<u>07</u>	<u>07</u>

#### 1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 22.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??
  - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 17 1/8" (Outside to outside)
  - ii. adjust upper stop for height if required

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
<u>07</u>	<u>07</u>	<u>07</u>	<u>07</u>	<u>07</u>

#### 2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01)

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.



# CARGO BASKET HOOP FABRICATION - 76423

AD 73-04 07  
AD 73-04 07  
AD 73-04 07  
AD 73-04 07  
Complete (initial or SCB #) 73-04 07

## 3. 1/2 Hoop Fabrication – 1" hoop

- Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- On the hoop bending fixture, set the following stops:
  - Upper tube stop: ??
  - Lower bend stop: ??
- Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- Slide shim all the way forward on bender to secure tube in die
- Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for angle using hoop jig. Adjust stops if required.
- Check for:
  - hoop height from jig
  - adjust upper stop for height if required
  - length to allow 60 degree cut.
- Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- De-burr cut end using a sanding disc on a die-grinder or disc sander.

AD 73-04 07  
AD 73-04 07  
AD 73-04 07  
AD 73-04 07  
AD 73-04 07

## 4. 1/2 Hoop Machining – 1" hoop

- Start with 1" 1/2 hoop as stock.
- Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
- Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Set tube in vise with 60 degree end on right.
- Using 1/2" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

AD 73-04 07  
AD 73-04 07  
AD 73-04 07  
AD 73-04 07  
AD 73-04 07

## 5. Joint Preparation

- Set 1" hoop in hoop jig. Insert 1/2" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto 1/2" hoop. Trim 1/2" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

AD 73-04 05  
AD 73-04 05  
AD 73-04 05  
AD 73-04 05  
AD 73-04 05

## 6. Welding – Lugs

- Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- TIG weld all around both sides of lugs. 2 places.
- Record lug and welding rod PO/WO on attached material list.

# CARGO BASKET HOOP FABRICATION - 76423

## 7. Welding – Handle Bushings – 84262-01

- Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- TIG weld bushing both sides, 2 bushings per hoop.
- Record bushing and welding rod PO/WO on attached material list.

## 8. Welding – Hoop Assembly

- Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- TIG weld around ½" hoop in slot.
- Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- Record cap and welding rod PO/WO on attached material list.

## 9. Finishing and Inspection

- Run 3/8-24 tap through welded lugs.
- Grind inside surfaces flush at lugs and slot in 1" tube.
- Inspect hoop for conformity to drawing.
- Tag complete and inspected hoop(s) and place into stock.

Work Order: 2016-47Material Tracking Sheet  
Eurocopter AS350 / AS355  
Hoop Fabrication

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	5		76423-01	Hoop - attachment (aft)		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099/15072
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	16002
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 2		76423-05	Stud	1018 Mild Steel, 5/8" Dia.	2013-14/2015-66
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	2016-134
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	15035
	. A/R		--	Welding Rod	ER70S-2	14033
Step 9				Finishing and Inspection	None	



# CARGO BASKET HOOP FABRICATION - 76423

~~Medium / long~~  
AD-05

~~No lugs~~  
AD-05

## General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

## Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2016-47-C x5

Date Open: 22 Mar 16

Complete

(initial or SCA #)

AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07
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### 1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 22.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??"
  - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 17 1/8" (Outside to outside)
  - ii. adjust upper stop for height if required

AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07
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### 2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01)

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.



AD-07 AD-07 AD-07 AD-07 AD-07

## 3. 1/2 Hoop Fabrication - 1" hoop

- Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- On the hoop bending fixture, set the following stops:
  - Upper tube stop: ??
  - Lower bend stop: ??
- Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- Slide shim all the way forward on bender to secure tube in die
- Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for angle using hoop jig. Adjust stops if required.
- Check for:
  - hoop height from jig
  - adjust upper stop for height if required
  - length to allow 60 degree cut.
- Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- De-burr cut end using a sanding disc on a die-grinder or disc sander.

## 4. 1/2 Hoop Machining - 1" hoop

- Start with 1" 1/2 hoop as stock.
- Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
- Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Set tube in vise with 60 degree end on right.
- Using 1/2" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

## 5. Joint Preparation

- Set 1" hoop in hoop jig. Insert 1/2" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto 1/2" hoop. Trim 1/2" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

6. Welding - Lugs *Changed to 5 long baskets*

- Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- TIG weld all around both sides of lugs. 2 places.
- Record lug and welding rod PO/WO on attached material list.

*This section to be completed. OK*

# CARGO BASKET HOOP FABRICATION - 76423

Complete  
(initial or SCA #)

## 7. Welding – Handle Bushings – 84262-01

- Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- TIG weld bushing both sides, 2 bushings per hoop.
- Record bushing and welding rod PO/WO on attached material list.

## 8. Welding – Hoop Assembly

- Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- TIG weld around ½" hoop in slot.
- Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- Record cap and welding rod PO/WO on attached material list.

## 9. Finishing and Inspection

- Run 3/8-24 tap through welded lugs.
- Grind inside surfaces flush at lugs and slot in 1" tube.
- Inspect hoop for conformity to drawing.
- Tag complete and inspected hoop(s) and place into stock.



Work Order: 2016-47Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Hoops

1 of 1

Date Opened: March 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	N/A		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	
	5		76423-07	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	.1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	.1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	16002
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	.2		76423-06	Stud	1018 Mild Steel, 5/8" Dia.	2015-66
Step 7	.2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	15024
Step 8	.1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	15035
	A/R		--	Welding Rod	ER70S-2	14005
Step 9				Finishing and Inspection	None	

# CARGO BASKET HOOP FABRICATION - 76423

Long

## General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

## Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order: 2016-47-B x5

Date Open: 22 Mar 16

long

Complete

(initial or SCA #)

AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07
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### 1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 22.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??"
  - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 17 1/8" (Outside to outside)
  - ii. adjust upper stop for height if required

AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07	AD 73-04 07
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### 2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01)

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.



AD-07 AD-07 AD-07 AD-07 AD-07

## 3. ½ Hoop Fabrication – 1" hoop

- Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- On the hoop bending fixture, set the following stops:
  - Upper tube stop: ??
  - Lower bend stop: ??
- Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- Slide shim all the way forward on bender to secure tube in die
- Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for angle using hoop jig. Adjust stops if required.
- Check for:
  - hoop height from jig
  - adjust upper stop for height if required
  - length to allow 60 degree cut.
- Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- De-burr cut end using a sanding disc on a die-grinder or disc sander.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
01	01	01	01	01

## 4. ½ Hoop Machining – 1" hoop

- Start with 1" ½ hoop as stock.
- Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
- Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Set tube in vise with 60 degree end on right.
- Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
01	01	01	01	01

## 5. Joint Preparation

- Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 6. Welding – Lugs

- Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- TIG weld all around both sides of lugs. 2 places.
- Record lug and welding rod PO/WO on attached material list.

**Complete**  
(initial or SCA #)

- ed in step 2. above.
- pop.
- |           |           |           |           |           |
|-----------|-----------|-----------|-----------|-----------|
| <u>05</u> | <u>05</u> | <u>05</u> | <u>AD</u> | <u>AD</u> |
|           |           |           | 73-04     | 73-04     |
|           |           |           | 05        | 05        |

- 73-04 ~~05~~      73-04 ~~05~~      73-04 ~~05~~      73-04 ~~05~~      73-04 ~~05~~

- to hold hoop together to complete welds out of

- 73-04 73-04 73-04 73-04 73-04

- \_\_\_\_\_ " tube.
- \_\_\_\_\_ into stock.



Work Order: 2016-47Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Hoops

1 of 1

Date Opened: March 2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	N/A		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	
	5		76423-07	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	.1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	.1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	16002
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	.2		76423-06	Stud	1018 Mild Steel, 5/8" Dia.	2015-66
Step 7	.2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	15024
Step 8	.1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	15035
	A/R		--	Welding Rod	ER70S-2	14005
Step 9				Finishing and Inspection	None	

## CARGO BASKET HOOP FABRICATION - 76423

Complete

Medium

## General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

## Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order:

2016-47 x5

Date Open:

22 Mar 16

Complete

(initial or SCA #)

AD  
73-04  
01AD  
73-04  
01AD  
73-04  
01AD  
73-04  
01AD  
73-04  
01

## 1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 22.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??"
  - ii. Lower bend stop: 12mm
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 17 1/8" (Outside to outside)
  - ii. adjust upper stop for height if required

AD  
73-04  
01AD  
73-04  
01AD  
73-04  
01AD  
73-04  
01AD  
73-04  
01

## 2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01)

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.



## 3. ½ Hoop Fabrication – 1" hoop

AD-07 AD-07 AD-07 AD-07 AD-07

- Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- On the hoop bending fixture, set the following stops:
  - Upper tube stop: ??
  - Lower bend stop: ??
- Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- Slide shim all the way forward on bender to secure tube in die
- Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for angle using hoop jig. Adjust stops if required.
- Check for:
  - hoop height from jig
  - adjust upper stop for height if required
  - length to allow 60 degree cut.
- Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- De-burr cut end using a sanding disc on a die-grinder or disc sander.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
01	01	01	01	01

## 4. ½ Hoop Machining – 1" hoop

- Start with 1" ½ hoop as stock.
- Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
- Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Set tube in vise with 60 degree end on right.
- Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
01	01	01	01	01

## 5. Joint Preparation

- Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

AD	AD	AD	AD	AD
73-04	73-04	73-04	73-04	73-04
05	05	05	05	05

## 6. Welding – Lugs

- Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- TIG weld all around both sides of lugs. 2 places.
- Record lug and welding rod PO/WO on attached material list.

# CARGO BASKET HOOP FABRICATION - 76423

AD 73-04 05	AD 73- 05	AD 73-04 05	Complete (initial or SCAM) AD 73-04 05	AD 73-04 05
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## 7. Welding – Handle Bushings – 84262-01

- Insert 84271-01 bushings into ½" hoop prepared in step 2. above.
- TIG weld bushing both sides, 2 bushings per hoop.
- Record bushing and welding rod PO/WO on attached material list.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 8. Welding – Hoop Assembly

- Insert 1" hoop from step 6 and ½" hoop from step 7 into hoop jig. Seat ½" hoop into slot in 1" hoop.
- Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- TIG weld around ½" hoop in slot.
- Cap ½" – 1" tube joint with 76423-04 cap. TIG weld around cap.
- Record cap and welding rod PO/WO on attached material list.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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## 9. Finishing and Inspection

- Run 3/8-24 tap through welded lugs.
- Grind inside surfaces flush at lugs and slot in 1" tube.
- Inspect hoop for conformity to drawing.
- Tag complete and inspected hoop(s) and place into stock.



Work Order: 2016-47Material Tracking Sheet  
Eurocopter AS350 / AS355  
MEI Hoop Fabrication

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	5		76423-01	Hoop - attachment (aft)		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	.1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	13087
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	.1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	16002
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	.2		76423-05	Stud	1018 Mild Steel, 5/8" Dia.	2015-66
Step 7	.2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	15024
Step 8	.1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	15035
	A/R		--	Welding Rod	ER70S-2	14005
Step 9				Finishing and Inspection	None	

Complete

Long

## General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

## Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order:

2016-47

x5

long

Complete  
(initial or SCA #)

Date Open:

22 Mar 16

AD-07 AD-07 AD-07 AD-07 AD-07

## 1. ½ Hoop Fabrication – ½" hoop

- a. Cut ½" x 0.035 material to 22.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??" <sup>12 3/8</sup>
  - ii. Lower bend stop: ~~12mm~~ <sup>103°</sup>
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 17 1/8" (Outside to outside)
  - ii. adjust upper stop for height if required

## 2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01)

AD-05 AD-05 AD-05 AD-05 AD-05

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.

## 3. ½ Hoop Fabrication – 1" hoop

AD-07 AD-07 AD-07 AD-07 AD-07

- a. Cut 1" x 0.065 material to 28.0", one end square, one end @ 16 degrees.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ??
  - ii. Lower bend stop: ?? 101°
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for angle using hoop jig. Adjust stops if required.
- j. Check for:
  - i. hoop height from jig
  - ii. adjust upper stop for height if required
  - iii. length to allow 60 degree cut.
- k. Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- l. De-burr cut end using a sanding disc on a die-grinder or disc sander.

## 4. ½ Hoop Machining – 1" hoop

AD-07 AD-07 AD-07 AD-07 AD-07

- a. Start with 1" ½ hoop as stock.
- b. Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
- c. Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Set tube in vise with 60 degree end on right.
- f. Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- g. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- h. Tag in process hoop(s) and place into stock.

## 5. Joint Preparation

AD-07 AD-07 AD-07 AD-07 AD-07

- a. Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

## 6. Welding – Lugs

AD-05 AD-05 AD-05 AD-05 AD-05

- a. Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- b. TIG weld all around both sides of lugs. 2 places.
- c. Record lug and welding rod PO/WO on attached material list.



## 7. Welding – Handle Bushings – 84262-01

AD-05 AD-05 AD-05 AD-05 AD-05

- a. Insert 84271-01 bushings into  $\frac{1}{2}$ " hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

## 8. Welding – Hoop Assembly

AD-05 AD-05 AD-05 AD-05 AD-05

- a. Insert 1" hoop from step 6 and  $\frac{1}{2}$ " hoop from step 7 into hoop jig. Seat  $\frac{1}{2}$ " hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around  $\frac{1}{2}$ " hoop in slot.
- d. Cap  $\frac{1}{2}$ " – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

## 9. Finishing and Inspection

AD-07 AD-07 AD-07 AD-07 AD-07

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2016-47

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Hoops

1 of 1

Date Opened: 22-March-2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1			76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	
			76423-07	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	. 1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	. 1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	16002
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	. 2		76423-06	Stud	1018 Mild Steel, 5/8" Dia.	2016-66
Step 7	. 2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	15024
Step 8	. 1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	15035
	. A/R		--	Welding Rod	ER70S-2	14005
Step 9				Finishing and Inspection	None	

Complete

Long

## General

These instructions apply to cargo basket attachment hoop 76423-01 (medium AS350 basket) and 76423-07 (long AS350 basket). Refer to the following drawings, at the current revision, for dimensions and details:

76423, Revision 2 – Attachment Hoop

84262, Revision 1 – Handle Bracket Assembly

## Notes

1. Always bend 1 hoop start to finish to ensure stops and stock length are correct.
2. Always pull with consistent speed through the bend, do not stop during the pull, and do not over-pull once the stop is reached.

Work Order:

2016-47 x5

long

Complete

(initial or SCA #)

Date Open:

22 Mar 16

## 1. ½ Hoop Fabrication – ½" hoop

AD-07 AD-07 AD-07 AD-07 AD-07

- a. Cut ½" x 0.035 material to 22.0", square ends.
- b. Record material PO on attached material list.
- c. De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- d. Remove writing on tubes with acetone and scotch bright.
- e. On the hoop bending fixture, set the following stops:
  - i. Upper tube stop: ?? 12<sup>5</sup>/<sub>8</sub>
  - ii. Lower bend stop: 12mm 103°
- f. Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- g. Slide shim all the way forward on bender to secure tube in die
- h. Pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- i. Check tube bend for square using a hoop jig or carpenters square. Adjust stops if required.
- j. Check for:
  - i. hoop height: 17 1/8" (Outside to outside)
  - ii. adjust upper stop for height if required

## 2. ½ Hoop Machining – ½" hoop – Handle Provisions (84262-01)

AD-05 AD-05 AD-05 AD-05 AD-05

- a. Start with ½" half hoop from step 1.
- b. Setup manual milling machine with specific hoop vise jaw. Set XY 0 on far, right edge of jaw (end of hoop).
- c. Drill 2 places, 5/16" (0.313) holes using 5/16" (#4) centre drill through both sides in accordance with drawing. Run at 500 RPM. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
  - i. locate 0.23" from edge (within tolerance specified on drawing).
- d. Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- e. Tag in process hoop(s) and place into stock.



## 3. ½ Hoop Fabrication – 1" hoop

~~AD-07~~

AD-07 AD-07 AD-07 AD-07 AD-07

- Cut 1" x 0.065 material to ~~28.0"~~, one end square, one end @ 16 degrees.
- Record material PO on attached material list.
- De-burr cut ends using a sanding disc on a die-grinder or disc sander.
- Remove writing on tubes with acetone and scotch bright.
- On the hoop bending fixture, set the following stops:
  - Upper tube stop: ??
  - Lower bend stop: ??
- Slide stock tube through bending die up to upper stop. Rotate bending arm clockwise until tube is secure, ready to bend. Ensure tube remains tight to upper stop.
- Slide shim all the way forward on bender to secure tube in die
- Using a long snipe tube, pull bending arm clockwise until stop is reached. Pull slowly with consistent pressure.
- Check tube bend for angle using hoop jig. Adjust stops if required.
- Check for:
  - hoop height from jig
  - adjust upper stop for height if required
  - length to allow 60 degree cut.
- Using hoop jig, mark for 60 degree cut on bottom end. Cut to length.
- De-burr cut end using a sanding disc on a die-grinder or disc sander.

## 4. ½ Hoop Machining – 1" hoop

AD-07 AD-07 AD-07 AD-07 AD-07

- Start with 1" ½ hoop as stock.
- Setup manual milling machine with standard steel vise jaws. Insert hoop into vise flat on bottom of vise, 16 degree side on right. Set XY 0 on far, right edge of hoop (end of hoop). Shift X along hoop 0.893" and set X 0. Shift Y -0.5". Set stop against end of tube.
- Drill two places, 5/8" (0.625) holes using 5/8" (#7) centre drill through both sides in accordance with drawing. Apply a few drops of Rapid-Tap cutting oil to each location before drilling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Set tube in vise with 60 degree end on right.
- Using ½" coated carbide end mill, mill slot 2.25" deep (edge to edge, 2.0 edge to centre). Apply a bead of Rapid-Tap cutting oil along cut line before milling.
- Wipe or blow off cutting oil and de-burr with scotch-brite disc on die-grinder.
- Tag in process hoop(s) and place into stock.

## 5. Joint Preparation

AD-07 AD-07 AD-07 AD-07 AD-07

- Set 1" hoop in hoop jig. Insert ½" hoop into 1" hoop, against side stop of jig. Mark slot location in 1" hoop onto ½" hoop. Trim ½" hoop with vertical bandsaw if required, and shape to match slot with disc sander.

## 6. Welding – Lugs

AD-05 AD-05 AD-05 AD-05 AD-05

- Insert two 76423-05 lugs (medium basket) or 76423-06 lugs (long basket) into holes in 1" hoop. Seat flush with inboard face of tube using a C-clamp or vise. Attach 11" spacing jig with 3/8-24 bolts to lugs.
- TIG weld all around both sides of lugs. 2 places.
- Record lug and welding rod PO/WO on attached material list.

## 7. Welding – Handle Bushings – 84262-01

AD-05 AD-05 AD-05 AD-05 AD-05

- a. Insert 84271-01 bushings into  $\frac{1}{2}$ " hoop prepared in step 2. above.
- b. TIG weld bushing both sides, 2 bushings per hoop.
- c. Record bushing and welding rod PO/WO on attached material list.

## 8. Welding – Hoop Assembly

AD-05 AD-05 AD-05 AD-05 AD-05

- a. Insert 1" hoop from step 6 and  $\frac{1}{2}$ " hoop from step 7 into hoop jig. Seat  $\frac{1}{2}$ " hoop into slot in 1" hoop.
- b. Tack weld hoops together, minimum 4 places, to hold hoop together to complete welds out of jig.
- c. TIG weld around  $\frac{1}{2}$ " hoop in slot.
- d. Cap  $\frac{1}{2}$ " – 1" tube joint with 76423-04 cap. TIG weld around cap.
- e. Record cap and welding rod PO/WO on attached material list.

## 9. Finishing and Inspection

AD-07 AD-07 AD-07 AD-07 AD-07

- a. Run 3/8-24 tap through welded lugs.
- b. Grind inside surfaces flush at lugs and slot in 1" tube.
- c. Inspect hoop for conformity to drawing.
- d. Tag complete and inspected hoop(s) and place into stock.

Work Order: 2016-47

Material Tracking Sheet  
Eurocopter AS350 / AS355  
Long Basket Hoops

1 of 1

Date Opened: 22-March-2016

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 1	N/A		76421-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	
	5		76423-07	Hoop - attachment		
Step 1				1/2 Hoop Fabrication - 1/2" hoop		
	.1		--	1/2" Tube - hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube	15072
Step 2				Machining	None	
Step 3				1/2 Hoop Fabrication - 1" hoop		
	.1		--	1" tube - hoop	4130 Steel, 1" x 0.065 Sqr. Tube	16002
Step 4				Machining	None	
Step 5				Joint Preparation	None	
				Welding		
Step 6	.2		76423-06	Stud	1018 Mild Steel, 5/8" Dia.	2015-66
Step 7	.2	84262	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Rnd. Tube	15024
Step 8	.1		76423-04	Cap	1018 Mild Steel, 0.050" Sheet	15035
	A/R		--	Welding Rod	ER70S-2	14005
Step 9				Finishing and Inspection	None	



long/medium

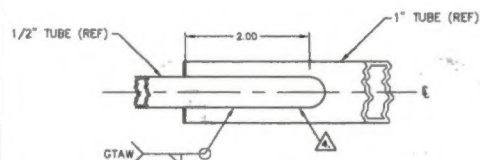
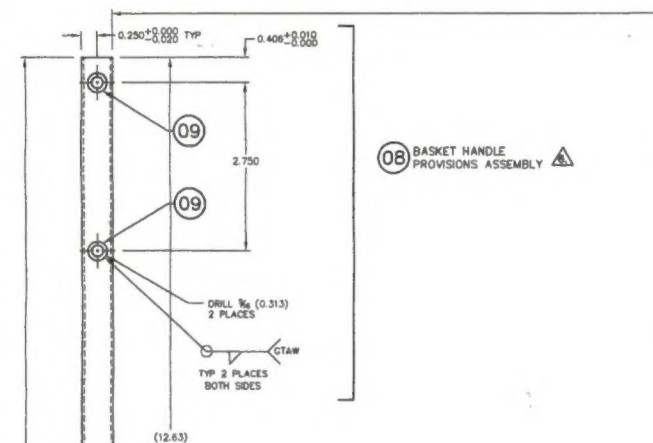
2016-47

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	RR	24 JAN 08
1	ADDED 76423-07 ASSY AND 76423-08 PART	RR	05 MAR 09
2	CHANGED LENGTH OF STUD (ITEM 05)	BUC	18 JUNE 10
3	TITLE BLOCK UPDATED; FORMAT UPDATED; LENGTH OF STUDS (ITEM 05 & 06)	BUC	14/05/2014
	CAP (ITEM 04) UPDATED; HANDLE PROVISIONS (ITEM 08) ADDED		

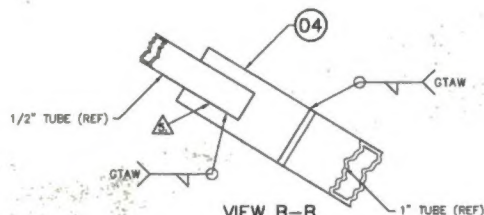
# NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
  2. DRILL #30 VENT HOLE IN HOOP FOR VENTING OF WELD GASES.
  3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS ER70S-2 OR EQUIVALENT.
- ⚠ MILL SLOT INTO ITEM 1" TUBE AS SHOWN. CONTOR END OF 1/2" TUBE TO MINIMIZE GAP BETWEEN 1" TUBE AND ITEM 1/2" TUBE.
- ⚠ ADJUST SLOT OF CAP (76423-04) TO FIT AS REQUIRED.
- ⚠ BASKET HANDLE PROVISIONS ARE INSTALLED IN ACCORDANCE WITH AERO DESIGN DRAWING 84262. DIMENSIONS AND PARTS SHOWN ARE FOR REFERENCE ONLY.

08 BASKET HANDLE PROVISIONS ASSEMBLY



VIEW A-A  
SCALE 1 : 1



VIEW B-B  
SCALE 1 : 1

01 ATTACHMENT HOOP ASSEMBLY  
SCALE 1 : 1

07 ATTACHMENT HOOP ASSEMBLY  
USED ON 78411  
ALL FEATURES SIMILAR TO 76423-01 EXCEPT STUDS. SEE SECTION C-C  
SCALE 1 : 1

VIEW C-C  
SCALE 1 : 1  
TYPICAL 2 PLACES

05 STUD  
SCALE 1 : 1

06 STUD  
SCALE 1 : 1

04 CAP  
SCALE 1 : 1

2	1	84272-01	08 BUSHING					
1	1	84262-01	08 BASKET HANDLE PROVISIONS ASSEMBLY					
2	2	76423-06	06 STUD	MILD STEEL	AISI 1010/1020	#0.63 ROD		
1	1	76423-05	05 STUD	MILD STEEL	AISI 1010/1020	#0.63 ROD		
1	1	76423-04	04 CAP	MILD STEEL SHEET	AISI 1010/1020	0.050 SHEET		
A/R/A/R	1	03	TUBE 1/2IN	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 SQ. TUBE		
A/R/A/R	1	02	TUBE 1IN	4130 STEEL COND. N	MIL-T-8736	1 X 0.065 SQ. TUBE		
		76423-07	07 ATTACHMENT HOOP ASSEMBLY	(USED ON 78411)				
		76423-01	01 ATTACHMENT HOOP ASSEMBLY					
08	07	01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	QTY	QTY						
LIST OF MATERIALS								
APPROVALS				DATE		 <b>AERO DESIGN LTD.</b> 8088A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G5 TEL: 954.685.9376 www.aerodesign.ca		
DRAWN: R. RATHWELL				24 JAN 08				
CHECKED: E. BURGON								
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:						<b>EUROCOPTER AS350 &amp; AS355 SERIES QUICK RELEASE CARGO BASKET ATTACHMENT HOOP ASSEMBLY</b>		
DECIMALS				ANGLES				
X.XXX ±0.010				X.XX ±1/2'				
X.XX ±0.03								
X.X ±0.1								
SHEET 1 OF 1				DWG SIZE		DWG NO.		REV.
				A1		76423		3



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Lug

No. of pieces: 34

Manufacturer: Aero Design Ltd.

Part No.: 76423-06

Serial / Batch No.: \_\_\_\_\_

TTSN: N/A

TSO: N/A

Rem.: N/A

Work Order No.: 2015-66

Remaining Tasks to be Performed: weld in place

Signature: David M. [Signature]

Date: Feb 15 / 2016

Lic. No. / SCA AD-05

**In Process**



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**In Process**

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